

Date: Wednesday, 6/27/2007 1:08:25 PM  
 User: Kim Johnston

## Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 33222	
Estimate Number : 11086	
P.O. Number : <i>N/A</i>	Part Number : D31761
This Issue : 6/27/2007 S.O. No. :	Drawing Number : D3176 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25028	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/20/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>6</i> Um: Each
Comment : Est Rev:B Removed -3 05-11-29 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R1000	303 Round Bar 1.0"
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Comment: Qty.: 0.3255 f(s)/Unit Total : 1.3020 f(s)

Material: AISI 303 SS 1.00 round bar

Ref: Dart Spec: M303R1.000)

Batch: *M18429**S.F. / [Signature] 07/07/11*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA286 &amp; DWG D3176

2-Deburr

*S.F. / [Signature] 07/07/11 DTP 07/07/12 (6)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DTP 07/07/12 (6) S.F. / [Signature] 07/07/11*

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE



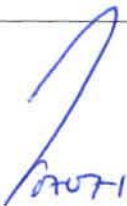


1- Mill flats as per dwg D3176

2- Deburr

*DTP 07/07/12 (6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/07/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/12	2.0	$\phi$ of Shoulder to small $(\phi 745 \pm .005)$ by 0.0005 - Flat before .375 Radius to long on the .277" dimension - $\phi .472$ " is under size on threaded end by 0.001"	 05/10/12	change programme  Part acceptable, all other dims are good.	 07/07/12	 07/07/12	 05/10/12	 07/07/12

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33222

Part Number: D31761

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DSP 07/07/12 (6)*

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*St 07-07-12 (6)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*St 07/07/12 (6)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*St 07/07/13 (6)*

Job Completion



*u 07-07-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

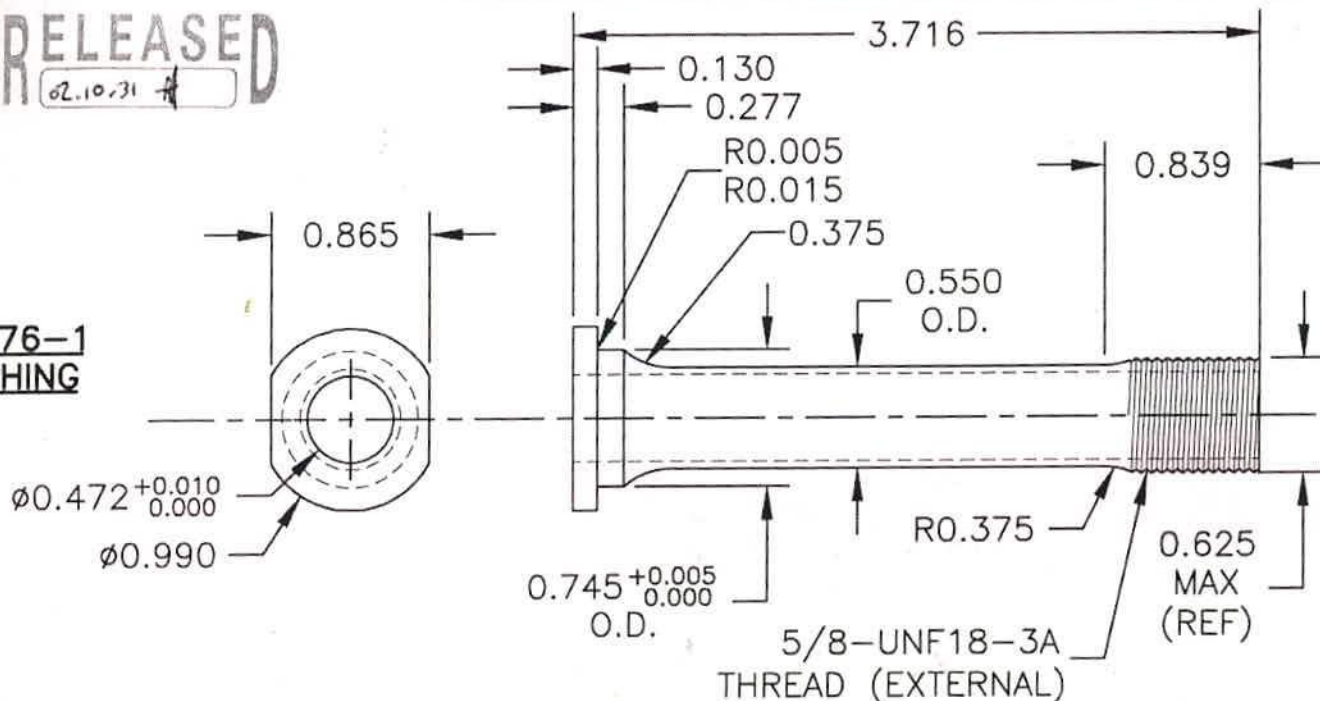




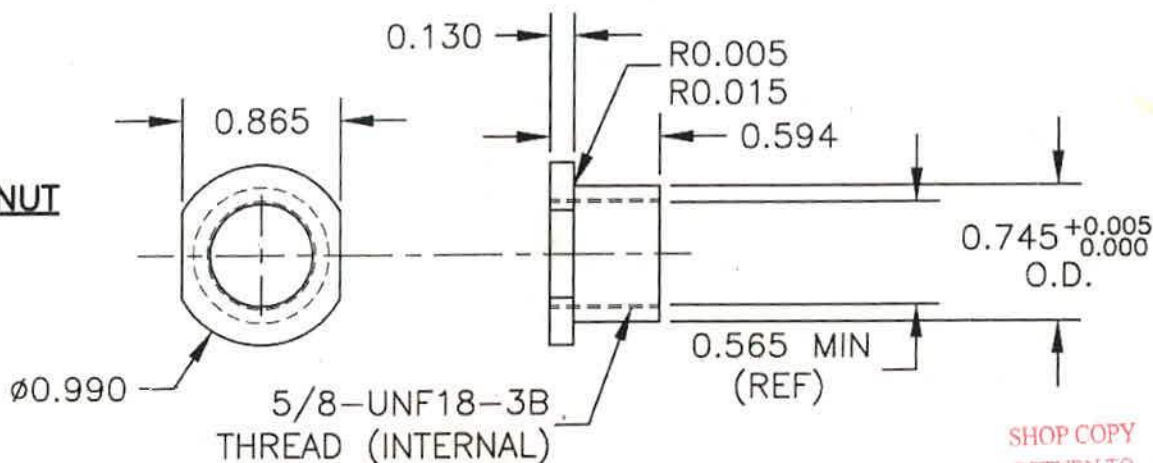
DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

RELEASED  
02.10.31

**D3176-1  
BUSHING**



**D3176-3 NUT**



**D3176-1/-3**

- 1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
- 2) THREADS PER MIL-S-7742
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) FINISH: NONE
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) D3176-1/-3 ARE MATING PARTS

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33222

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